

Date: Friday, 11/18/2005 3:18:54 PM  
User: Linda Lacelle

## Process Sheet

SPLIT split again

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)  
Job Number : 24840 -3  
Estimate Number : 10534  
P.O. Number : N/A Part Number : D2574  
This Issue : 11/18/2005 S.O. No. : N/A Drawing Number : D2574 REV D  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : MACHINED PARTS Drawing Revision : D  
Previous Run : 244341 Material : N/A Qty: 4  
Written By : See comment below Due Date : 12/20/2005 (12) Um: Each  
Checked & Approved By : See comment below  
Comment : Est: P02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2574KJ

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

0

D6101005

7075-T7351 8.25X5.0X2.5



Comment: Qty: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 8.25X5.0X2.5

Make from D6101-005 billet for D2574

Ensure that grain is along 5.00" length

Batch No: 7075-T7A (2x)

Billet X2

MS 06/01/08

4

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No: 7075-T7A Double check by: En 06/01/09

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

N/A (5) Tumble to remove sharp edges.

-MS 06/01/09

-MS 06/01/09  
J.G.

4

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 &amp; D2574

J.G. - MS 06/01/09

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 20/10/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 24840

Part Number: D2574

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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-MS 06/01/09  
J.G 4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SG 06-01-10 4

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FF 06-01-11 4

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MA 06 01 16 4

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

CZ 06/01/17 4

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 373

CZ 06/01/17 4

10.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

505 06/01/18 (4) 150 06/01/18 (4)

Job Completion





JART AEROSPACE LTD		Work Order:	
Description: Saddle, Aft Inboard		Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.440	✓	✓	✓		
B	1.745	1.755		1.754	1.752	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.505	3.501		
D	1.745	1.755		1.753	1.751	1.750	1.750		
E	7.990	8.010		8.005	8.002	8.004	8.003		
F	0.490	0.510		0.501	.500	.497	.502		
G	0.257	0.262	DT8683	0.258	0.258	✓	✓		
H	0.375	0.380	DT8684	0.376	0.376	✓	✓		
I	0.490	0.510		0.508	.500	.499	.501		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		0.674	.511	.565	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.375	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.123	4.123	4.122	4.123		
P	0.115	0.135		0.125	.125	.128	.129		
Q	0.115	0.135		0.125	.133	.133	.128		
R	0.240	0.260		0.252	.251	.252	.248		
S	0.115	0.135		0.123	.122	.127	.125		
T	0.178	0.198		0.1875	.180	.188	.188		
U	3.210	3.250		3.230	3.231	3.233	3.232		
V	0.230	0.250		0.243	.244	.240	.234		
W	0.115	0.135		0.123	.132	.135	.128		
X	0.307	0.312							
Y	0.760	0.765							
Z	0.352	0.372		0.357	.311	.302	.304		
AA	0.470	0.530		0.500	.500	.500	.500		
AB	0.615	0.635		0.633	.625	.628	.626		
AC	0.053	0.073		0.063	.063	.063	.063		
AD	0.240	0.260		0.240	.250	.250	.248		
AE	1.500	1.520		1.514	1.511	1.512	1.511		
AF	0.115	0.135		0.125	.133	.133	.135		
AG	0.240	0.280		0.255	.260	.252	.269		
AH	0.240	0.260		0.248	.250	.250	.249		
AI	2.000	2.020		2.002	2.002	2.002	2.002		
AJ	0.023	0.043							
Accept/Reject				Reject					

Measured by:		Audited by:	BC 06.01.10
Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED  
05.20





# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 17, 2005  
03:30 pm

Work Order No	: 0024840	Department Code:	
Project Name	: D2574	Burden Flags	: NNNNNNN
Project For	: WK550	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
Edge part Number	: D2574	Invoice Number	:
Description	: Saddle, Aft, In	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Rec'd	: 12	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 11-15-05	Actual Margin	: 0.000%
Est Finish Date	:		
Act Finish Date	:		
Inventory Status	: No		
Est Approval	:		
Approval Part's	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
Overhead Hours	0.00	0.00	0.00		
Overhead Cost	0.00	0.00	0.00	0.00	0.00
PMC Hours	0.00	0.00	0.00		
PMC Cost	0.00	0.00	0.00	0.00	0.00
MIS'g. Hours	0.00	0.00	0.00		
MIS'g. Cost	0.00	0.00	0.00	0.00	0.00
<b>Burden</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>		
<b>Total Cost</b>	<b>0.00</b>	<b>0.00</b>	<b>0.00</b>		
<b>Margin</b>	<b>0.000</b>	<b>0.000</b>			
<b>Rolling Cost</b>	<b>0.00</b>	<b>0.00</b>			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00